

Date: Monday, 27/04/2009 11:41:48 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT			
Job Number	: 47486		Part Number	: D2565111			
Estimate Number	: 10285		Drawing Number	: D2565 REV E			
P.O. Number	:		Project Number	: N/A			
This Issue	: 27/04/2009	S.O. No. :	Drawing Revision	: E			
Prsht Rev.	: NC		Material	:			
First Issue	: //	Type	: SMALL /MED FAB				
Previous Run	: 41896		Due Date	: 01/05/2009		Qty: 10 Um: Each	
Written By	:						
Checked & Approved By	: <u>JUD 09/04/2012</u>						
Comment	: Est: E 01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC Est: E 06.05.03 Change level 2/8 to QC5 EC						
Additional Product							
Job Number: 							
Seq. #:	Machine Or Operation:	Description :					
1.0	M304TR0750W049	304 RD Tube .750 x .049W 					
Comment: Qty.: 1.1944 f(s)/Unit Total : 11.9438 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) Batch No: <u>M111457</u> 						<u>SB 09/04/2012</u> (10)	
2.0	BRAKE NC	NC BRAKE 					<u>Pt6</u> (10) 
Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313						<u>SB 07/04/2012</u> (10)	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 					<u>10X</u> (10) 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr and polish 						<u>09/04/30</u> (10)	
4.0	QC5	INSPECT WORK TO CURRENT STEP 					
Comment: INSPECT WORK TO CURRENT STEP						<u>8/09/11</u> (10) 	
5.0	POWDER COATING	POWDER COATING 					
Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3						<u>m111472</u> (10) 	
START TIME:		8:25		OVEN TEMPERATURE:		400°	
FINISH TIME:		9:55					
						<u>FL 09/05/12</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2565-111 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 47486		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/30	# 2.0	Parts Found 2 be to short by 1.00" P.C. Human error.	<u>05/04/12</u>	Label incorrect parts with mat# and Batch #'s And Put aside For D2565-405 Replace B# <u>07/05/31</u>	W/0 47486 09/05/11	<u>S</u> <u>09/05/11</u>	<u>05/04/12</u>	<u>S</u> 07/05/30
				114-57				

NOTE: Date & initial all entries

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Drawing Name: STRUT

Job Number: 47486

Part Number: D2565111

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10



10

Comment: INSPECT POWDER COAT

09-05-12

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST270

SS 09/05/12

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/13 dJ

Job Completion



MF  
09-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

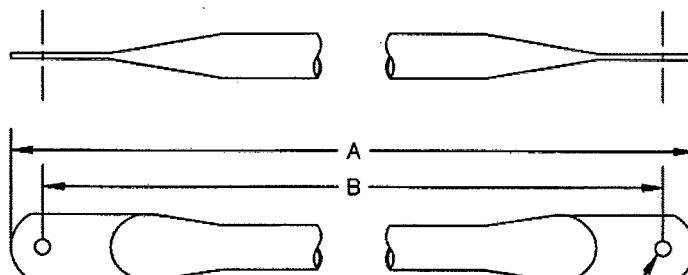
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3

**RELEASED**  
 04.05.05


PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

GENERAL NOTES
 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
 (REF. DART SPEC. M304TR0.750W0.049)  
 ENSURE SEAMLESS TUBE IS USED

SHOP COPY

RETURN TO

ENGINEERING

 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005  
 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 44-1080

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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